

WHAT IS CLAIMED IS:

1 1. A double-face velour fabric article comprises a fabric body having a technical face
2 formed by a filament stitch yarn and a technical back formed by a filament loop yarn, said
3 filament stitch yarn comprising heat sensitive material, said fabric body having a velour
4 surface formed at both said technical back and said technical face, and said heat sensitive
5 material responding to application of heat during processing to increase tortuosity with a
6 result of said fabric body having permeability of about 80 ft³/ft²/min or less under a pressure
7 difference of ½ inch of water across the fabric body.

1 2. The double-face velour fabric article of claim 1, wherein said heat sensitive
2 material comprises hot melt material.

1 3. The double-face velour fabric article of claim 1, wherein said heat sensitive
2 material comprises heat shrinkable material.

1 4. The double-face velour fabric article of claim 1, wherein said heat sensitive
2 material is selected from the group consisting of polypropylene, polyester, and polyamide.

1 5. The double-faced velour fabric article of claim 1, claim 2, claim 3, or claim 4,
2 wherein said heat sensitive material responds to application of dry heat.

1 6. The double-faced velour fabric article of claim 1, claim 2, claim 3, or claim 4,
2 wherein said heat sensitive material responds to application of wet heat.

1 7. The double-faced velour fabric article of claim 6, wherein said heat sensitive
2 material responds to application of wet heat applied by steam.

1 8. The double-faced velour fabric article of claim 6, wherein said heat sensitive
2 material responds to application of wet heat applied by hot water.

1 9. The double-faced velour fabric article of claim 1, claim 2, claim 3, or claim 4,
2 wherein said heat sensitive material responds to application of heat at about 212°F to about
3 450°F applied for about 2 minutes to about 60 minutes.

1 10. The double-faced velour fabric article of claim 1, claim 2, claim 3, or claim 4,
2 wherein said filament stitch yarn comprises elastomeric material.

1 11. The double-faced velour fabric article of claim 10, wherein said elastomeric
2 material comprises spandex.

1 12. The double-faced velour fabric article of claim 10, wherein filaments of said heat
2 sensitive material and filaments of said elastomeric material are commingled together.

1 13. The double-faced velour fabric article of claim 10, wherein filaments of said heat
2 sensitive material and filaments of said elastomeric material are plaited together.

1 14. The double-faced velour fabric article of claim 10, wherein raised fibers of the
2 velour surface of at least one of the technical face and the technical back is entangled,
3 including in and/or through interstices of the fabric body toward the other of the technical
4 face and the technical back.

1 15. The double-face velour fabric article of claim 14, wherein raised fibers of the
2 technical back are entangled, including in and/or through interstices of the fabric body,
3 toward the technical face.

1 16. The double-faced velour fabric article of claim 1, claim 2, claim 3, or claim 4,
2 wherein said filament stitch yarn is a cored yarn comprising a core and a sheath, said sheath
3 comprising hot melt material.

1 17. The double-face velour fabric article of claim 16, wherein said hot melt material
2 is selected from the group consisting of polypropylene, polyester and polyamide.

1 18. The double-face velour fabric article of claim 16, wherein said core comprises a
2 material selected from the group consisting of polyester and nylon.

1 19. The double-faced velour fabric article of claim 1, wherein said filament loop yarn
2 splits to release multiple small diameter filaments.

1 20. The double-faced velour fabric article of claim 19, wherein said filament loop
2 yarn splits by application of heat to release said multiple small diameter filaments.

1 21. The double-faced velour fabric article of claim 20, wherein said filament loop
2 yarn comprises an "islands-in-sea" construction.

1 22. The double-faced velour fabric article of claim 19, wherein said filament loop
2 yarn splits by application of a chemical treatment to release said multiple small diameter
3 filaments.

1 23. The double-faced velour fabric article of claim 19, wherein said filament loop
2 yarn splits by application of a mechanical action to release said multiple small diameter
3 filaments.

1 24. The double-face velour fabric article of claim 1, wherein said filament loop yarn
2 is textured.

1 25. The double-face velour fabric article of claim 1, wherein said filament stitch yarn
2 is textured.

1 26. The double-faced velour fabric article of claim 1, claim 2, claim 3, or claim 4,
2 wherein raised fibers of the velour surface of at least one of the technical face and the
3 technical back is entangled, including in and/or through interstices of the fabric body toward
4 the other of the technical face and the technical back.

1 27. The double-face velour fabric article of claim 26, wherein raised fibers of the
2 technical back are entangled, including in and/or through interstices of the fabric body,
3 toward the technical face.

1 28. A double-face velour fabric article comprises a fabric body having a technical
2 face formed by a filament stitch yarn and a technical back formed by a filament loop yarn,
3 said filament stitch yarn comprising elastomeric material, said fabric body having a velour
4 surface formed at both said technical back and said technical face, and said fabric body
5 having permeability of about 80 ft³/ft²/min or less under a pressure difference of ½ inch of
6 water across the fabric body.

1 29. The double-face velour fabric article of claim 28, wherein said elastomeric
2 material comprises spandex.

1 30. The double-face velour fabric article of claim 1 or claim 28, wherein said fabric
2 body has permeability of about 70 ft³/ft²/min or less.

1 31. The double-faced velour fabric article of claim 28, wherein raised fibers of the
2 velour surface of at least one of the technical face and the technical back is entangled,
3 including in and/or through interstices of the fabric body toward the other of the technical
4 face and the technical back.

1 32. The double-face velour fabric article of claim 31, wherein raised fibers of the
2 technical back are entangled, including in and/or through interstices of the fabric body,
3 toward the technical face.

1 33. A double-face velour fabric article comprises a fabric body having a technical
2 face formed by a filament stitch yarn and a technical back formed by a filament loop yarn,
3 said fabric body having a velour surface formed at both said technical face and said technical
4 back, with raised fibers of the velour surface of at least one of the technical face and the
5 technical back entangled, including in and/or through interstices of the fabric body toward

6 the other of the technical face and the technical back, said fabric body having permeability of
7 about 80 ft³/ft²/min or less under a pressure difference of ½ inch of water across the fabric
8 body.

1 34. The double-face velour fabric article of claim 33, wherein raised fibers of the
2 technical back are entangled, including in and/or through interstices of the fabric body,
3 toward the technical face.

1 35. A double-face velour fabric article comprises a fabric body having a technical
2 face formed by a filament stitch yarn and a technical back formed by a filament loop yarn,
3 said fabric body having a velour surface formed at both said technical face and said technical
4 back, with said fabric body having permeability of about 80 ft³/ft²/min or less under a
5 pressure difference of ½ inch of water across the fabric body, wherein, after finishing, at least
6 one of the technical face and the technical back is subjected to hydroentanglement to
7 entangle raised fibers of the velour surface, including in and/or through interstices of the
8 fabric body, thereby to densify the fabric body and increase tortuosity.

1 36. The double-face velour fabric article of claim 35, wherein, after finishing, raised
2 fibers of the technical back are entangled, including in and/or through interstices of the fabric
3 body, toward the technical face.

1 37. The double-face velour fabric article of claim 1, claim 28, claim 33, or claim 35,
2 wherein at least one of said filament stitch yarn and said filament loop yarn is a yarn of fine
3 denier filaments or fibers.

1 38. A method of forming a double-face velour fabric body, said method comprising
2 the steps of:

3 joining a filament loop yarn and a filament stitch yarn to form a fabric prebody, the
4 filament stitch yarn forming a technical face of the fabric prebody and the filament loop yarn
5 forming a technical back of the fabric prebody, the filament stitch yarn comprising heat
6 sensitive material,

7 finishing said technical face and said technical back of the fabric prebody, thereby to
8 form a double-face velour fabric body having opposite velour surfaces, and
9 exposing said fabric body to heating sufficient to cause a response by said heat
10 sensitive material, thereby to increase tortuosity with a result of said fabric body having
11 permeability of about $80 \text{ ft}^3/\text{ft}^2/\text{min}$ or less under a pressure difference of $\frac{1}{2}$ inch of water
12 across the fabric body.

1 39. A method of forming a double-face velour fabric body, said method comprising
2 the steps of:

3 joining a filament loop yarn and a filament stitch yarn to form a fabric prebody, with
4 the filament stitch yarn forming a technical face of the fabric prebody and the filament loop
5 yarn forming a technical back of the fabric prebody,

6 finishing the technical face and the technical back of the fabric prebody, thereby to
7 form a double-face velour fabric body having opposite velour surfaces, and

8 entangling raised fibers of at least one of the technical face and the technical back,
9 including in and/or through interstices of the fabric body, thereby to increase density and
10 tortuosity of the fiber body, the fabric body having permeability of about $80 \text{ ft}^3/\text{ft}^2/\text{min}$ or less
11 under a pressure difference of $\frac{1}{2}$ inch of water across the fabric body.

1 40. The method of forming a double-face velour fabric body of claim 39, comprising
2 the further step of entangling the raised fibers in a process of hydroentanglement, by
3 directing fine, high pressure jets upon at least one of the technical face and the technical
4 back.

1 41. The method of forming a double-face velour fabric body of claim 39 or claim 40,
2 comprising the further step of directing fine, high pressure jets upon the technical back, to
3 cause raised fibers of the velour surface of the technical back to entangle, including in and/or
4 through interstices of the fabric body, toward the technical face.

1 42. The method of forming a double-face velour fabric body of claim 39, wherein the
2 filament stitch yarn comprises heat sensitive material, and said method comprises the further

3 step of exposing said fabric body to heating sufficient to cause a response by the heat
4 sensitive material, thereby to increase tortuosity.

1 43. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 comprising exposing said fabric body to said heating sufficient to cause a response by said
3 heat sensitive material during dyeing.

1 44. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 comprising exposing said fabric body to said heating sufficient to cause a response by said
3 heat sensitive material during finishing.

1 45. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 comprising exposing said fabric body to dry heat.

1 46. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 comprising exposing said fabric body to wet heat.

1 47. The method of forming a double-face velour fabric body of claim 46, comprising
2 exposing said fabric body to steam.

1 48. The method of forming a double-face velour fabric body of claim 46, comprising
2 exposing said fabric body to hot water.

1 49. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 comprising exposing said fabric body to said heating sufficient to cause a response by said
3 heat sensitive material for about 2 minutes to about 60 minutes at about 212°F to about
4 450°F.

1 50. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 comprising joining a filament loop yarn and a filament stitch yarn, the filament stitch yarn
3 comprising elastomeric material.

1 51. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 comprising exposing said fabric body to heating sufficient to cause a response by said heat
3 sensitive material, thereby to increase tortuosity with a result of said fabric body having
4 permeability of about 70 ft³/ft²/min or less.

1 52. The method of forming a double-face velour fabric body of claim 38 or claim 42,
2 wherein the filament stitch yarn comprises elastomeric material.

1 53. A method of forming a double-face velour fabric body, said method comprising
2 the steps of:
3 joining a filament loop yarn and a filament stitch yarn to form a fabric prebody, the
4 filament stitch yarn forming a technical face of the fabric prebody and the filament loop yarn
5 forming a technical back of the fabric prebody, the filament stitch yarn comprising
6 elastomeric material, and
7 finishing said technical face and said technical back of the fabric prebody, thereby to
8 form a double-face velour fabric body having opposite velour surfaces and permeability of
9 about 80 ft³/ft²/min or less under a pressure difference of ½ inch of water across the fabric
10 body.

1 54. The method of forming a double-face velour fabric body of claim 50, claim 52 or
2 claim 53, wherein the elastomeric material comprises spandex.